

# Work Order ID 83489

**\*83489\***

Page 1

April-18-12 2:45:17 PM

Item ID: D2661-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, LH Fwd Aft Out 206  
 Start Date: 18/04/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 02/05/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100 0.00  
**\*100\*** HAAS CNC VERTICAL MACHINING #1  
 HAAS 1 Memo 0.00 PD/R 12/05/20 6 Ø  
 HAAS CNC vertical machine #1 Program part number and batch number.  
 Program part number and batch number  
 MACHINE AS PER DWG AND FOLIO FB073  
 FOLIO REV: AA  
 DWG REV: E

110 0.00  
**\*110\*** CONVENTIONAL MILLING MACHINE  
 Mill Conv Memo 0.00 6 Ø  
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet  
PD/R 12/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*83489\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 18/04/2012      **Start Qty:** 6.00

\*6\*

**Cust Item ID:**

**Required Date:** 02/05/2012      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

## Memo

0.00

QC

## Quality Control

130

QC8- Inspect parts - second check

0.00

**\*130\***

## Memo

0.00

QC

## Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

## Memo

0.00

HandFinish

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83489

\*83489\*

Page 3

April-18-12 2:45:17 PM

Item ID: D2661-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop \*NS2\*

Start Date: 18/04/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 11:45								
	FINISH TIME: 12:15								
	OVEN TEMPERATURE:								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC		0.00							
Quality Control									
	Memo								
170	Identify as per dwg & Stock Location: 51435	0.00							
<b>*170*</b>									
Packaging		0.00							
Packaging									
	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83489****\*83489\***

Page 4

April-18-12 2:45:17 PM

Item ID: D2661-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/5/23 JF  
MLJ 12/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-18-12 2:45:21 PM

Page 1

Work Order ID: 83489

\*83489\*

Parent Item: D2661-1

\*D2661-1\*

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	71.0000	1	6			
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\*D6101-003\*

Saddle Billet, 7075

\*\*

PO

12/05/19

## Location

## Loc Qty

## Loc Code

MAT040

26

73775

2

73780

7

78599

10

80765

0

MAT041

1

80765

1

MAT042

43

81924

50

MAT044

1

73769

1

→ 83310

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83489
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.257	0.257	0.257	0.257	0.257
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.677	1.677	1.677	1.677	1.677
F	1.357	1.367		1.361	1.361	1.361	1.361	1.361
G	0.100	0.140		0.129	0.129	0.127	0.127	0.127
H	0.210	0.230		0.239	0.222	0.217	0.218	0.218
I	0.615	0.685		0.680	0.685	0.685	0.685	0.685
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.337	1.323	1.320	1.320	1.321
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.142	1.139	1.134	1.133	1.136
O	0.100	0.180		0.135	0.140	0.140	0.140	0.140
P	0.100	0.140		0.112	0.114	0.116	0.118	0.117
Q	0.240	0.260		0.256	0.245	0.249	0.248	0.248
R	0.677	0.697		0.686	0.686	0.685	0.684	0.688
S	0.100	0.140		0.119	0.122	0.122	0.122	0.124
T	1.565	1.585		1.580	1.579	1.574	1.574	1.576
U	0.540	0.560		0.551	0.550	0.551	0.551	0.552
V	0.912	0.932		0.921	0.921	0.919	0.920	0.918
W	0.787	0.807		0.796	0.797	0.798	0.799	0.801
X	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.500	0.500	0.500	0.501	0.496
AA	0.312	0.319		0.314	0.314	0.314	0.314	0.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.502	0.502	0.504	0.504	0.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.239	0.239	0.239	0.237	0.237
AG	0.510	0.515		0.513	0.513	0.513	0.513	0.513
AH	0.100	0.120		0.115	0.115	0.114	0.112	0.113
AI								

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 83489	
<b>Description:</b> 206 Saddle, Outboard, Left side				<b>Part Number:</b> D2661-1	
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1/6	2	3	4	5
A	3.611	3.621	3.616	3.616				
B	0.256	0.263	0.257	0.257				
C	0.315	0.322	0.316	0.316				
D	2.495	2.505	2.500	2.500				
E	1.674	1.684	1.67	1.677				
F	1.357	1.367		1.361				
G	0.100	0.140		0.127				
H	0.210	0.230		0.218				
I	0.615	0.685		0.685				
J	2.470	2.510		2.490				
K	1.313	1.343		1.320				
L	0.178	0.198		0.188				
M	0.470	0.530		0.500				
N	1.125	1.145	1.134	1.134				
O	0.100	0.180		0.140				
P	0.100	0.140		0.116				
Q	0.240	0.260		0.248				
R	0.677	0.697		0.685				
S	0.100	0.140		0.122				
T	1.565	1.585	1.574	1.574				
U	0.540	0.560		0.550				
V	0.912	0.932		0.920				
W	0.787	0.807		0.798				
X	5.990	6.010		6.001				
Y	4.995	5.005		5.000				
Z	0.490	0.510		0.498				
AA	0.312	0.319		0.314				
AB	0.990	1.010		1.000				
AC	1.245	1.255		1.250				
AD	0.490	0.510		0.502				
AE	3.745	3.755		3.750				
AF	0.235	0.240		0.237				
AG	0.510	0.515		0.513				
AH	0.100	0.120		0.113				
AI								



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83485
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

<b>Measured by:</b> P. R.	<b>Date:</b> 12/05/20
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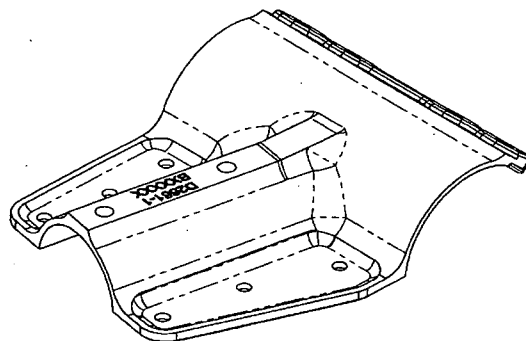
<b>Audited by:</b> B. A.	<b>Date:</b> 12/05/20
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<b>Prototype Approval:</b>	<b>Date:</b>
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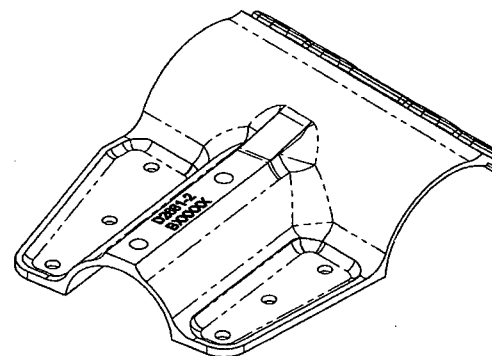
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095 DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 03489ML0

12/04/19



D2661-1 SADDLE, OUTSIDE, LH



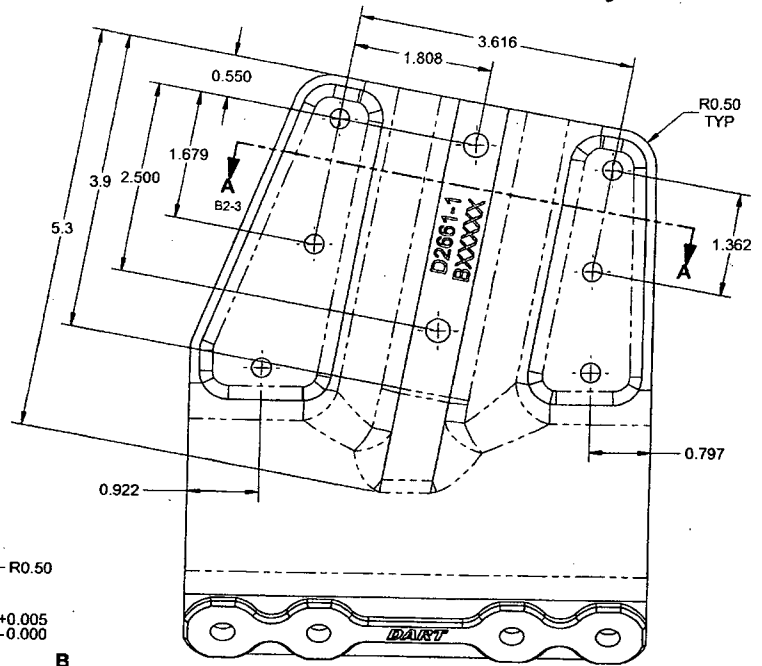
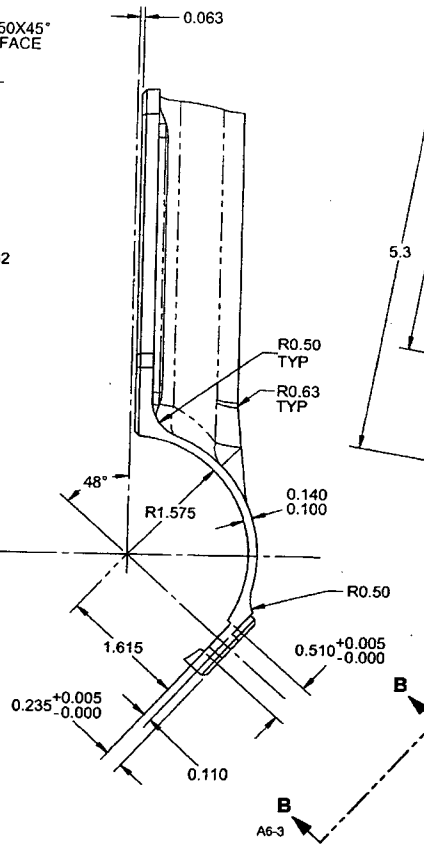
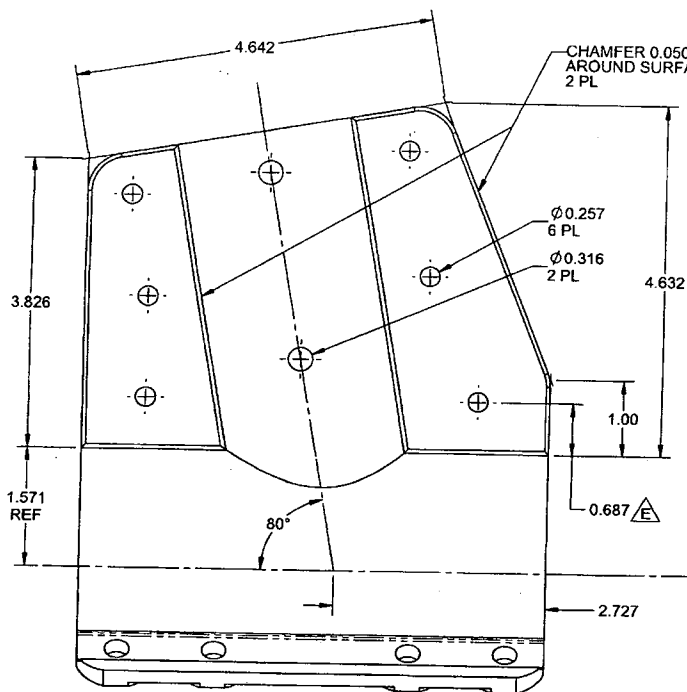
D2661-2 SADDLE, OUTSIDE, RH

RELEASED  
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2, B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	KENT, WA		
CHECKED	DRAWING NO. D2661		
MFG. APPR.	REV. E		
APPROVED	SHEET 1 OF 5		
DE APPR.	TITLE SADDLE, OUTSIDE		
DATE	11.10.31	SCALE NTS	

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83489



**D2661-1 SADDLE, OUTSIDE, LH**

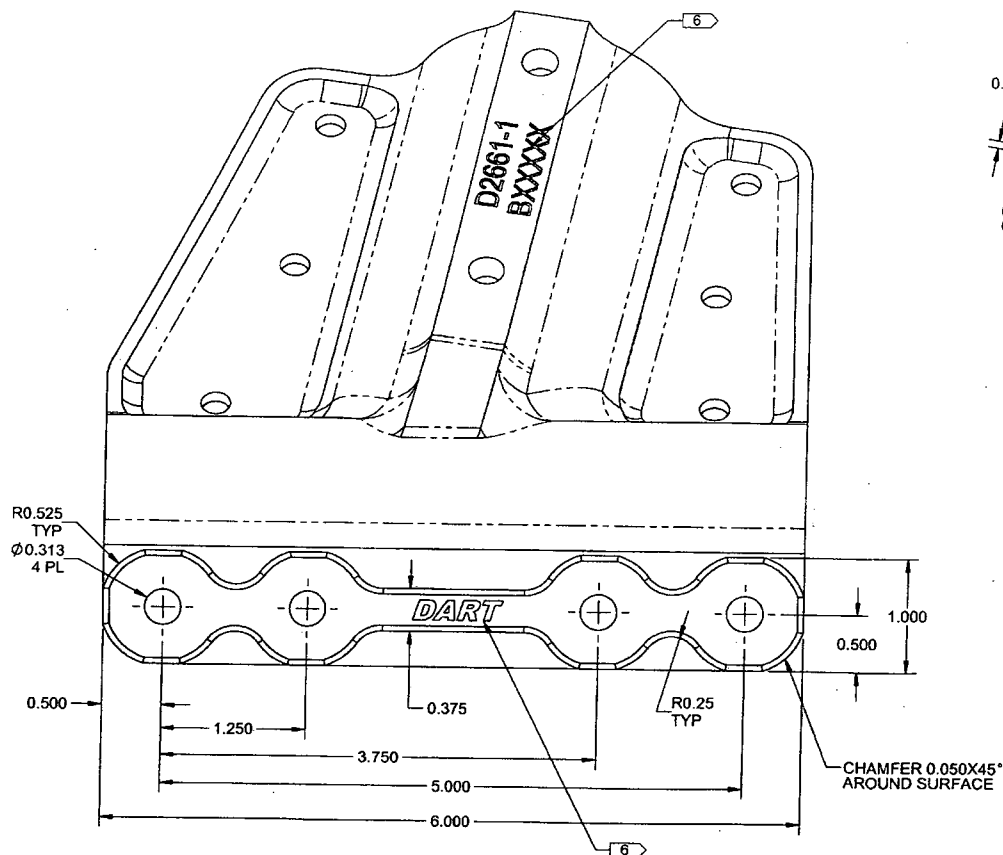
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

RELEASED  
2011-11-16

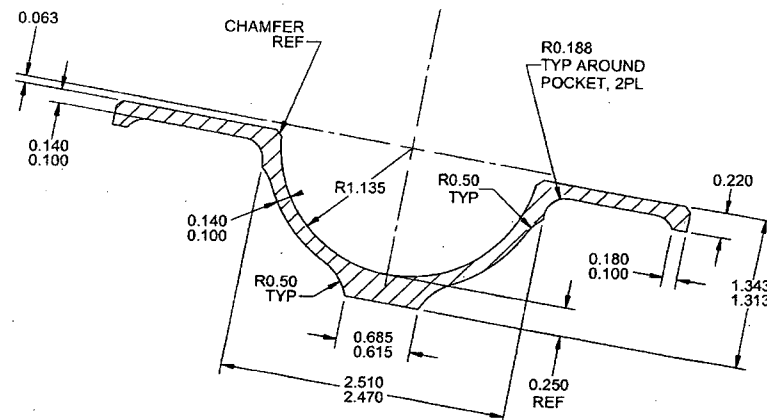
DESIGN	8	DART AEROSPACE USA, INC.	
DRAWN	ASS	KENT, WA	
CHECKED		DRAWING NO.	D2661
MFG. APPR.		REV. E	
APPROVED		SHEET 2 OF 5	
DE APPR.		TITLE	SADDLE, OUTSIDE
DATE	11.10.31	SCALE	NTS
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83489



VIEW B-B  
SCALE 1.5X A4-2  
VIEW ROTATED

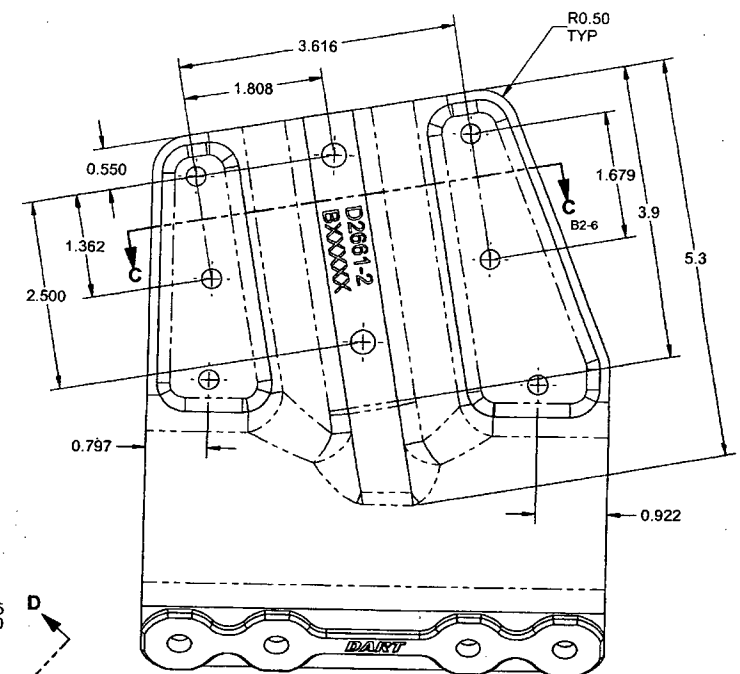
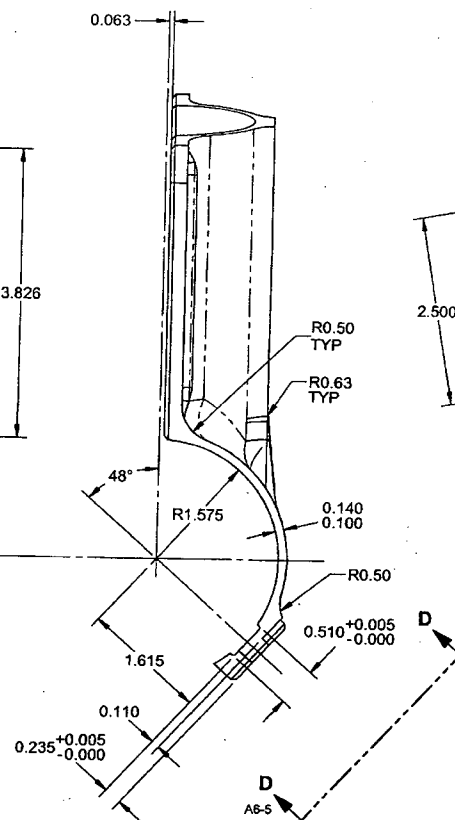
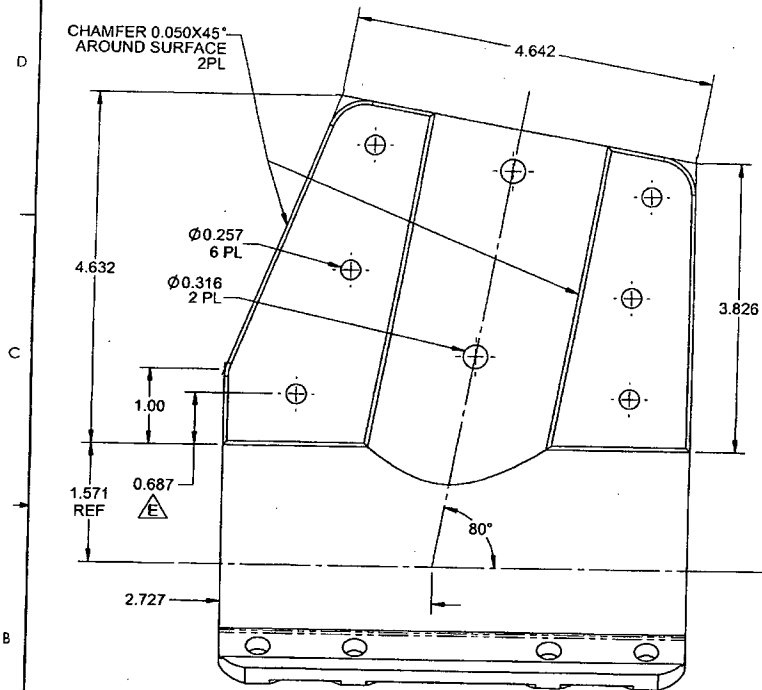


VIEW A-A C3-2  
SCALE 1.5X

RELEASED  
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	GR	KENT, WA	
CHECKED	RS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED	JMB	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

23489



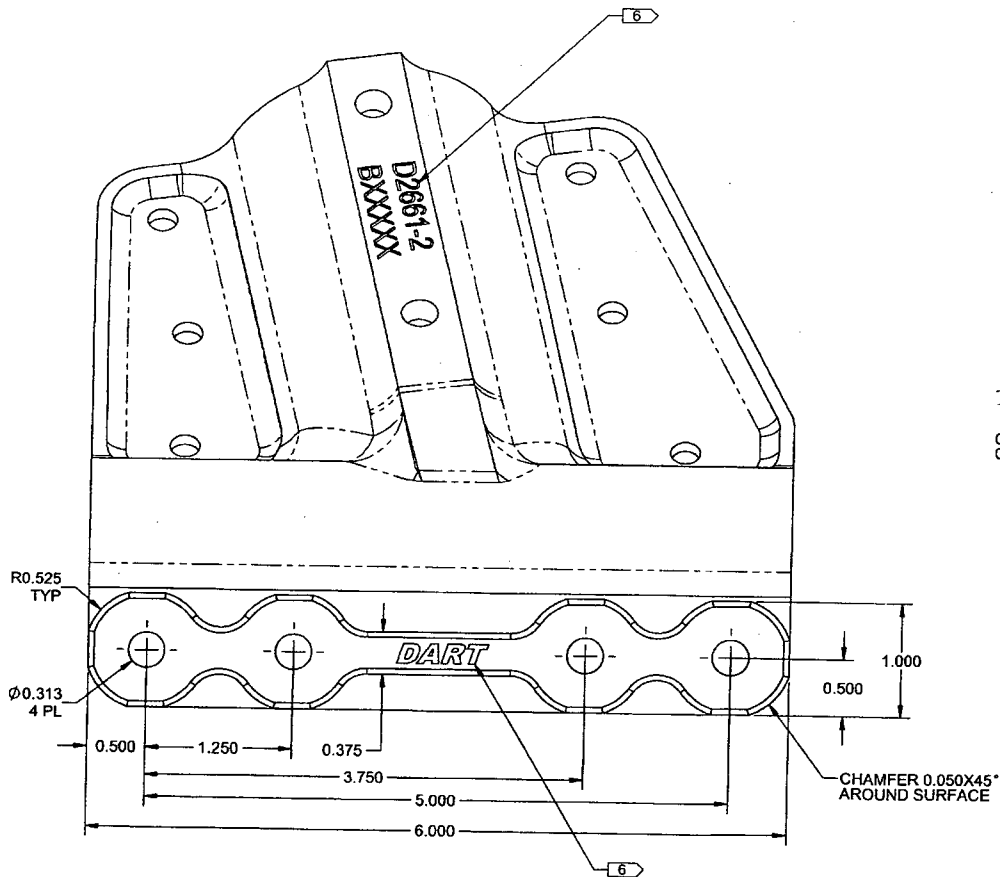
**D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

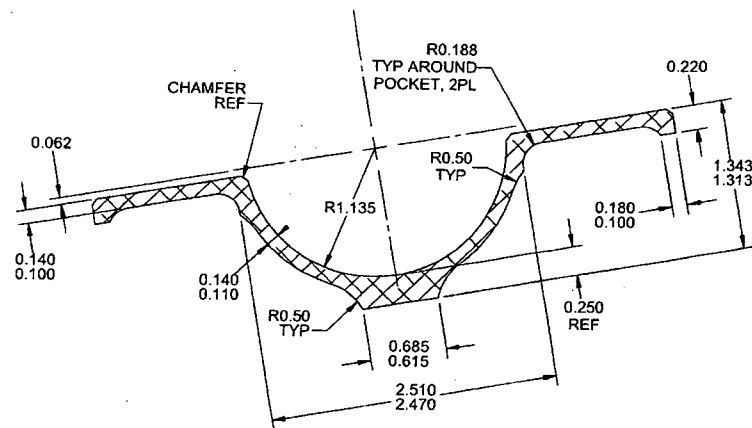
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DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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83489



**VIEW D-D** B4-4  
SCALE 1.5X  
VIEW ROTATED



**SECTION C-C** C1-4  
SCALE 1.5X

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2011-11-16

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DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. <b>D2661</b>	REV. E
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